

Work Order ID **76473*****76473***

Page 1

November-15-11 8:12:52 AM

Item ID: D3189-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chafing Shield

Start Date: 15/11/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 11/11/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3189

Rev B

100

0.00

100

SHEAR

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .020

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-12-1430

103

QC2- Inspect parts off machine FAI/FAIB

0.00

103

QC

Memo

0.00

Quality Control

B11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76473

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Page 2

November-15-11 8:12:52 AM

Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Chafing Shield
 Start Date: 15/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<i>counts</i> (430)			
110 *110* Small Fab Small Fab	Small Fab Memo <i>NIA</i> 1-Debur & Grind Rads as per Dwg D3189 2-Roll as per Dwg D3189 3-Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DS19549 and DEO D412-664-243.	0.00 0.00				(30)			
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(30) (430)			

Smurly

SP 11/12/20
→ AS 12-2-3

Smurly

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 76473

76473

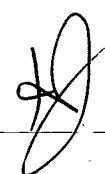
Page 3

November-15-11 8:12:52 AM

Item ID: D3189-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Chafing Shield
 Start Date: 15/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130						<u>12</u>	<u>12</u>	<u>2</u>	<u>6</u>
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/6 

MF
12-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

November-15-11 8:12:56 AM

Work Order ID: 76473

76473

Parent Item: D3189-1

D3189-1

Parent Item Name: Chafing Shield

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22 No longer made in-house KJ/JLM
 IPP Rev: C 06-03-24 Rolling Now made in House JLM
 IPP Rev: D 07-04-16 As per Rev B JLM
 11.05.11 now made on waterjet DD verf: JLM
 IPP Rev: E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	104.5000	0.32	6.736842	10		
M304S25GA									**			1311-12-14	
304/316 .020" Sheet													

Location

Loc Qty

Loc Code

MAT20

104.5

117285

5.5

118228

99

118228

30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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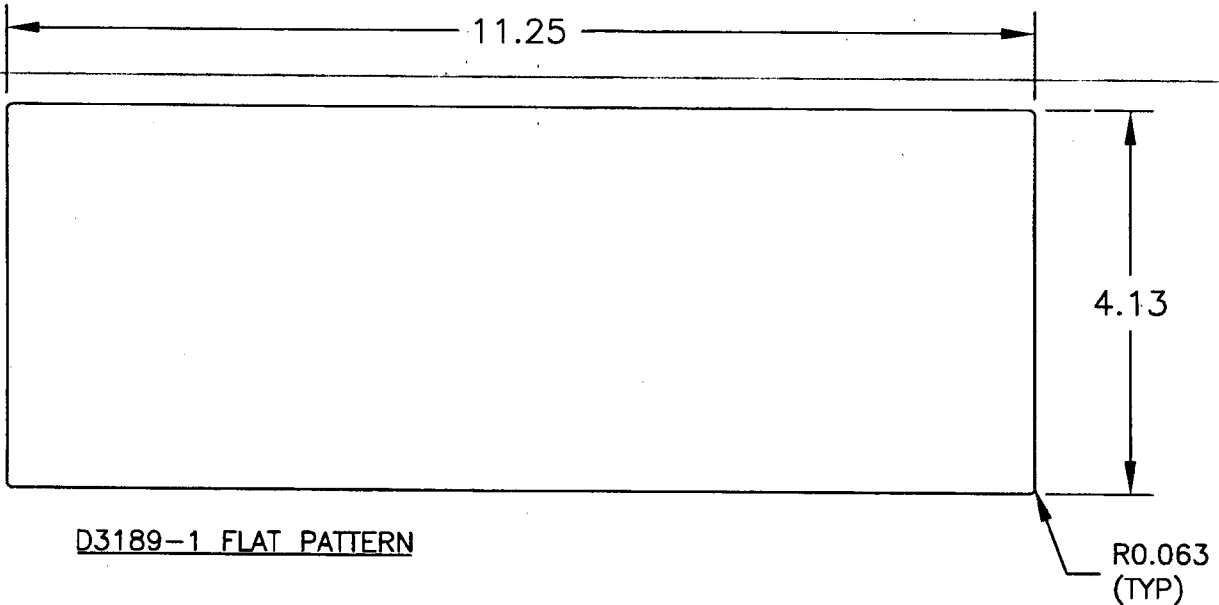
NOTE: Date & initial all entries

DART

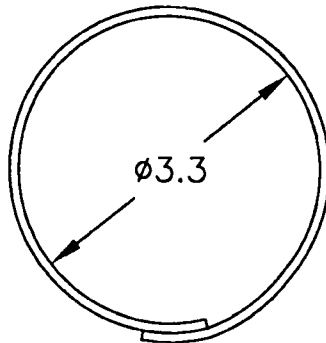
DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED

07.03.27 [Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76474



D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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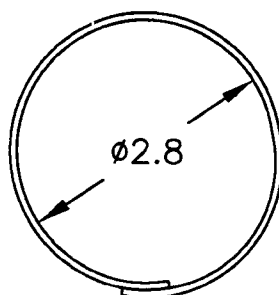
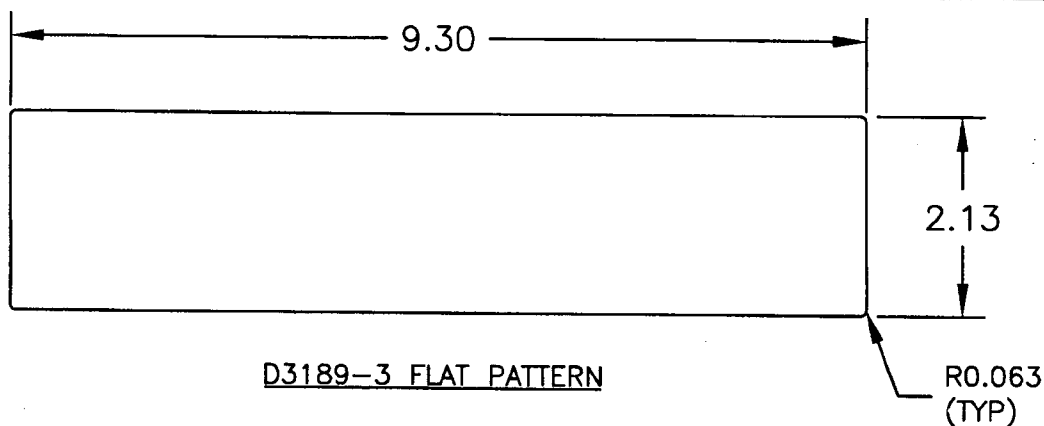


76474

DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 [Signature]



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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